

December-17-13 9:07:36 AM

Page 1

Time OUT: 7:00 am 14/01/07

Work Order ID 110074

December-17-13 9:07:36 AM

110074

Page 3

| | | | | | | |
|----------------|-------------------------|-----------------|---------------------|---------------|-------|--------------|
| Item ID: | D3281-2L08 | Accept | *N900040100* | Setup | Start | *NS1* |
| Revision ID: | | | | | Stop | *NS2* |
| Item Name: | Floor Protector, Fwd RH | | | | | |
| Start Date: | 12/13/13 | Start Qty: 4.00 | *4* | Cust Item ID: | | |
| Required Date: | 12/17/13 | Req'd Qty: 4.00 | *4* | Customer: | | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--------------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----------------|---|------|--|--|--|---|--|--|--|
| 150 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | 4 | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

| | | | | | | | | | |
|--------------|-----------|------|--|--|--|---|--|--|--|
| 160 | Packaging | 0.00 | | | | 4 | | | |
| *160* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

| | | | | | | | | | |
|-----------------|---|------|--|--|--|-----|--|--|--|
| 170 | QC21- Final Inspection - Work Order Release | 0.00 | | | | MLJ | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DAS
26
9-89

MLJ 14-01-28

Picklist Print

December-17-13 9:07:36 AM

Page 1

Work Order ID: 110074

Parent Item: D3281-2L08

Parent Item Name: Floor Protector, Fwd RH

Start Date: 12/13/13

Required Date: 12/17/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev. A 10.02.24 New Issue LL
Material 10/04/21 DL

IPP REv. B Add Step 105 Dry

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-----------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MLEXS.118-90318-08 Lexan Sheet | | Purchased | No | | | 100 | sf | 3,378.1600 | 5 | 21.052632 | | | |

Location

Loc Qty

Loc Code

therm

3378.16

113127

2.16

m126994

3376

21.053-sg Pk.

14/01/20

| | | | |
|---|---------------|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 110074 |
| Description: Floor Protector, Fwd RH | | Part Number: | D3281-2 |
| Inspection Dwg: D3281 | Rev: F | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than 0.1875" Go/No Go | ✓ | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |

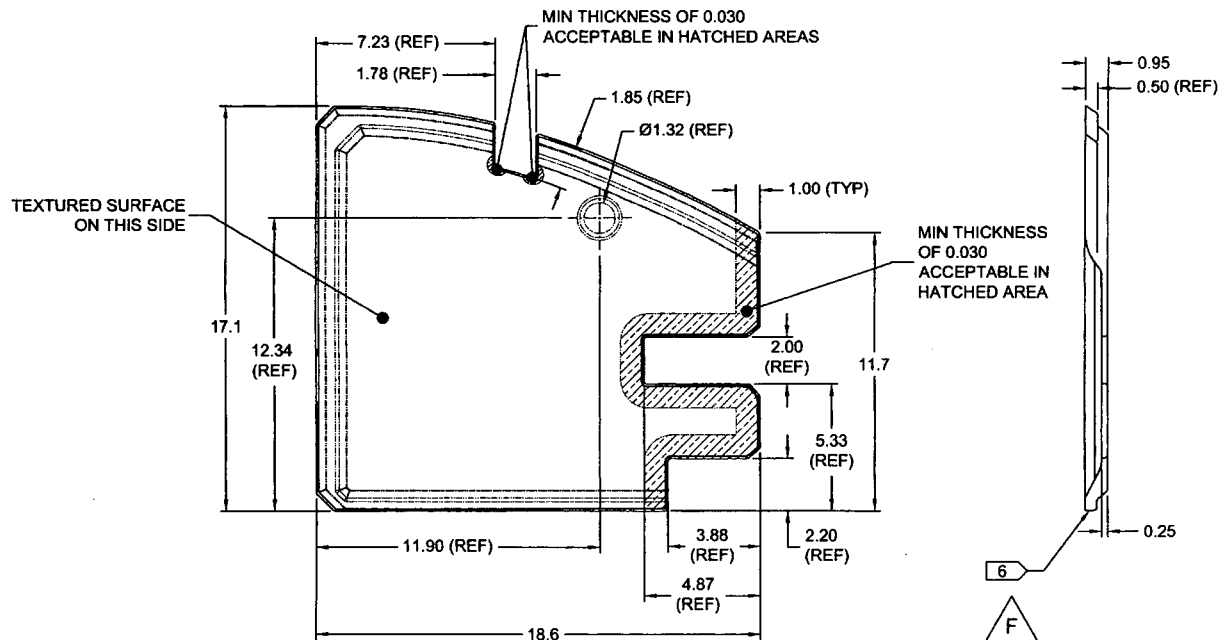
| | |
|------------------------|-----------------------|
| Measured by: <u>JB</u> | Date: <u>14/01/25</u> |
|------------------------|-----------------------|

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 18.3 | +/-0.100 | 18.35 | ✓ | | TH-05 | |
| 17.4 | +/-0.100 | 17.375 | ✓ | | TH-05 | |
| 12.1 | +/-0.100 | 12.12 | ✓ | | TH-05 | |
| 0.95 | +/-0.030 | .96 | ✓ | | TH-01 | |
| 0.25 | +/-0.030 | .295 | ✓ | | TH-01 | |
| 0.030 | Min | .079 | ✓ | | TH-01 | |
| 0.070 | Min | .102 | ✓ | | TH-01 | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | |
|---------------------------------|-----------------------|
| Measured by: <u>JB</u> | Date: <u>14/01/25</u> |
| Audited by: <u>DAS</u> | Date: <u>14/1/25</u> |
| Preliminary Approval: <u>27</u> | Date: <u>9-89</u> |

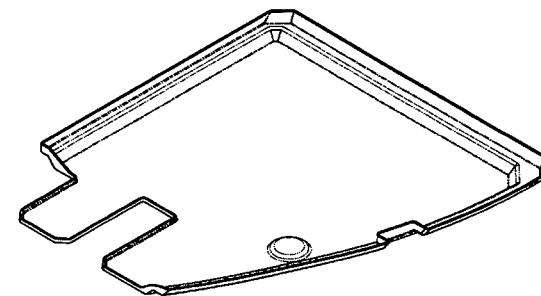
| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------------------------|------------|--------------------|
| A | 08.02.28 | New Issue | KJ/DL | |
| B | 08.04.16 | Dimensions updated per Dwg Rev D | KJ/DL | |
| C | 08.07.23 | Dwg Rev updated | KJ/DL | |
| D | 08.09.12 | Tolerance revised for 0.070 dimension | KJ/DL | |
| E | 10.09.01 | Dwg Rev updated | KJ | |
| F | 11.06.21 | Dwg Rev updated | KJ | <u>[Signature]</u> |



D3281-1 FLOOR PROTECTOR

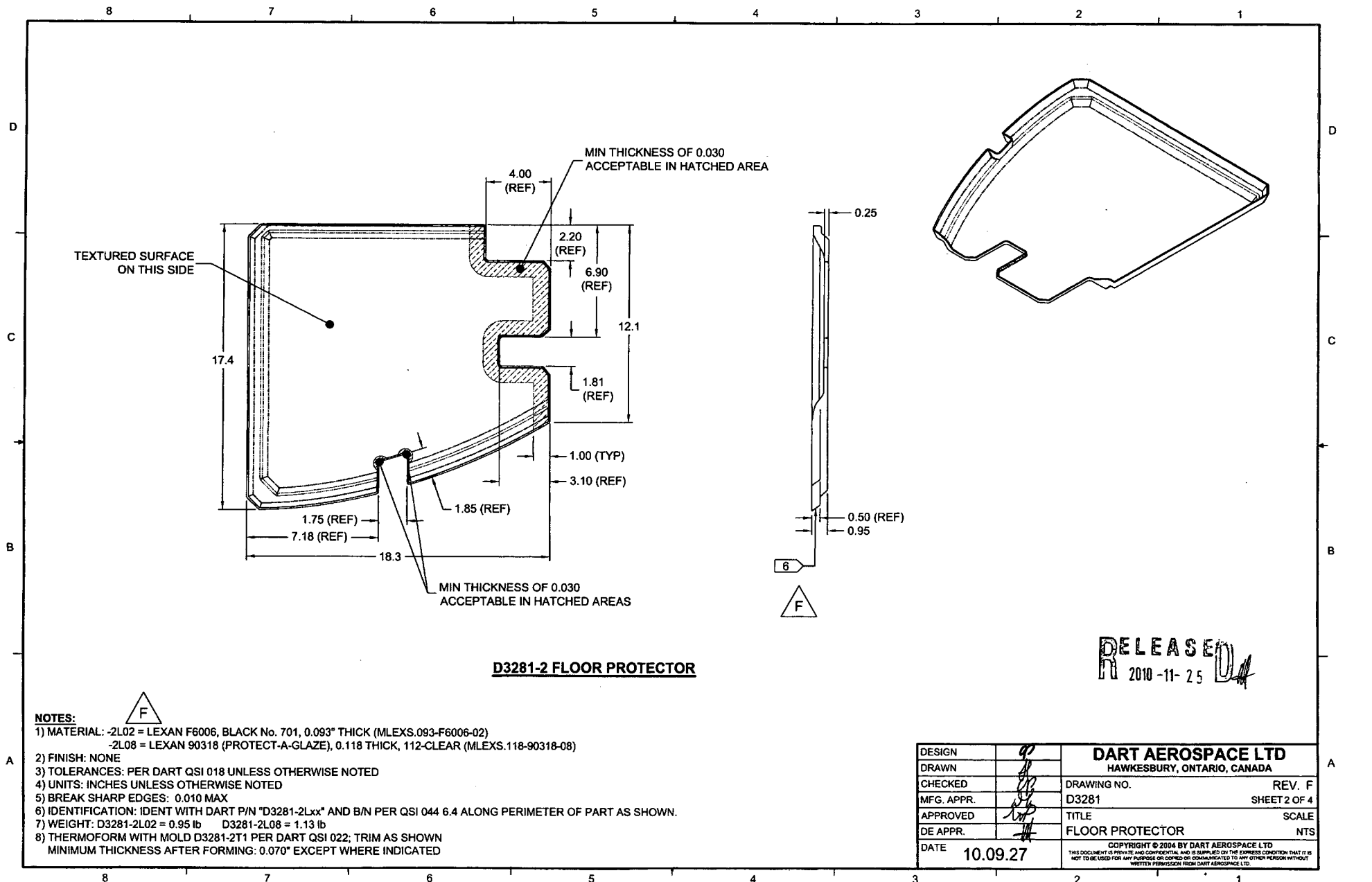
NOTES:

- 1) MATERIAL: -1L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-1L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENT WITH DART P/N "D3281-1Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-1L02 = 0.95 lb D3281-1L08 = 1.13 lb
- 8) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED



110074 MLS
13-12-19
RELEASED
2010-11-25

| REV. | DESCRIPTION | BY | DATE |
|--|--|-------|----------|
| F | NOTES UPDATED. FLAG NOTE 6 WAS 7 & RELOC, D.E.O. D3281-E-1 INC. DIM 17.0 WAS 17.1 (ZN B5-3, B6-4) & 17.7 WAS 17.8 (ZN C5-3, C6-4) REF CAR 10-21. | JPH | 10.09.27 |
| E | -3/4 NOW TRIMMED FLAT: RMV 0.25 BEVEL TO FACILITATE TRIMMING (ZN D6-3, D4-4) | CP | 10.01.05 |
| D | THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4) | PH | 08.03.28 |
| C | UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE | LE | 07.10.09 |
| B | NOW LEXAN; DIMS AS MANUFACTURED | CP | 05.11.25 |
| A | NEW ISSUE | CP | 04.05.03 |
| DESIGN | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3281 TITLE FLOOR PROTECTOR DATE 10.09.27 | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| DE APPR. | | | |
| REV. F | SHEET 1 OF 4 | SCALE | NTS |
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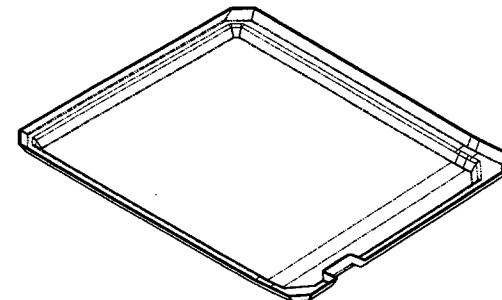
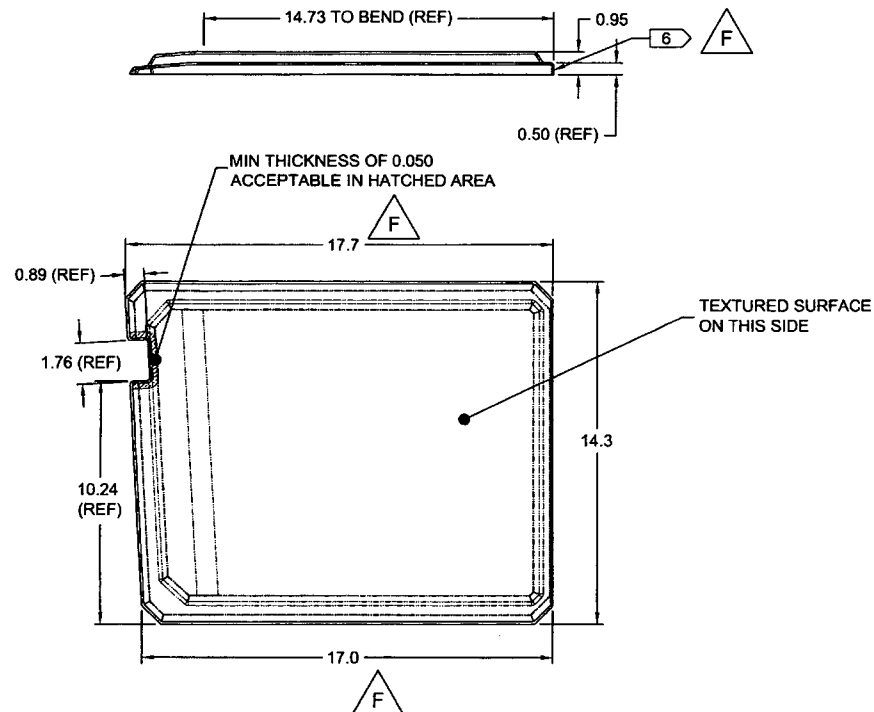


8 7 6 5 4 3 2 1

D

C

B



D

C

B

D3281-3 FLOOR PROTECTOR

RELEASE
2010-11-25

NOTES:

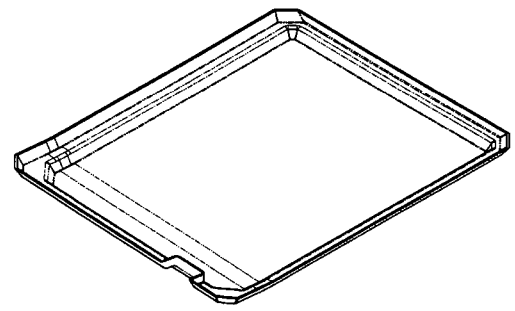
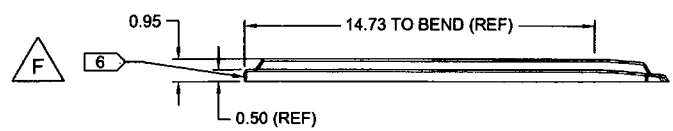
- 1) MATERIAL: -3L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-3L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENT WITH DART P/N "D3281-3Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-3L02 = 0.87 lb D3281-3L08 = 1.05 lb
- 8) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

| | | | |
|--|-----------|--|--------------|
| DESIGN | <i>JD</i> | DART AEROSPACE LTD | |
| DRAWN | <i>JD</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>JD</i> | DRAWING NO. | REV. F |
| MFG. APPR. | <i>JD</i> | D3281 | SHEET 3 OF 4 |
| APPROVED | <i>JD</i> | TITLE | SCALE |
| DE APPR. | <i>JD</i> | FLOOR PROTECTOR | NT |
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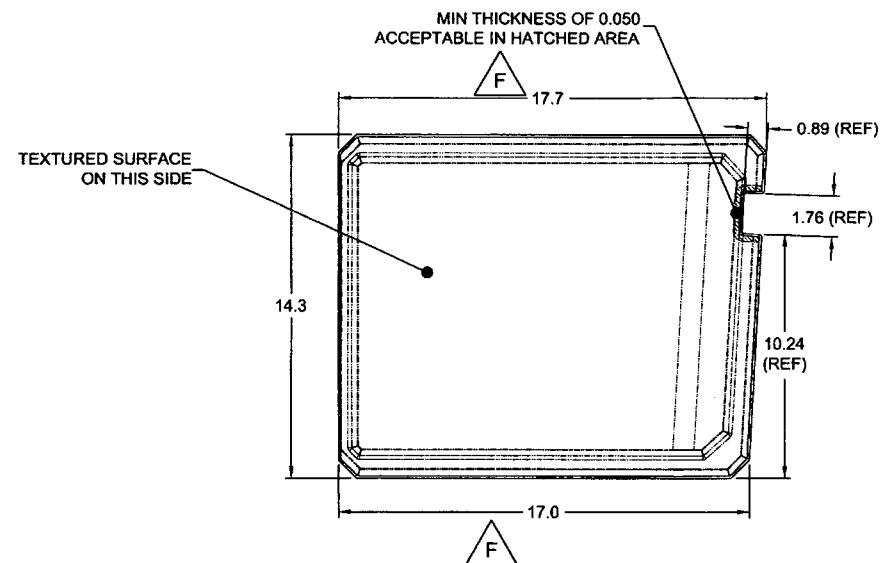
8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D



C



D3281-4 FLOOR PROTECTOR

B

A

- D3281-4 NOTES:**
- 1) MATERIAL: 4L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
4L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 MAX
 - 6) IDENTIFICATION: IDENT WITH DART P/N "D3281-4Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
 - 7) WEIGHT: D3281-4L02 = 0.87 lb D3281-4L08 = 1.05 lb
 - 8) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

RELEASE
2010-11-25

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D3281 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FLOOR PROTECTOR | NTS |
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8 7 6 5 4 3 2 1